

CLAIM SET AS AMENDED

1. (Currently Amended) A cast-iron insert around which another metal is to be cast, comprising:

a surface for contact with a molten mass of said other metal to be cast around the cast-iron insert-(10); and

a plurality of protrusions disposed on said surface and having respective substantially conical undercuts which are progressively spread outwardly from said surface,

wherein distal ends of said protrusions have respective flat faces ~~on distal ends thereof, the flat faces allowing the cast-iron insert to be securely held in face-to-face contact by a clamping mechanism,~~

wherein said undercuts have respective spherical contact portions, and said other metal is cast around said spherical contact portions, and

wherein said cast-iron insert comprises a cylinder liner.

2-3. (Canceled)

4. (Currently Amended) A method of manufacturing a cast-iron insert, comprising the steps of:

coating an inner surface of a mold with a facing material containing a thermally insulating material, a binder, a parting agent, a surface active agent, and water;

replacing an existing atmosphere in said mold with an inactive gas atmosphere; and

rotating said mold which has been coated with said facing material and simultaneously pouring molten cast iron into said mold, to produce a cast-iron insert having a surface for contact with a molten mass of another metal to be cast around the cast-iron insert, and a plurality of protrusions disposed on said surface and having respective substantially conical undercuts which are progressively spread outwardly from said surface[[],]; and

~~wherein positioning a clamping mechanism against respective flat faces formed at distal ends of said protrusions have respective flat faces on distal ends thereof in order to securely hold the cast-iron insert,~~

wherein said undercuts have respective spherical contact portions, and said other metal is cast around said spherical contact portions, and

wherein said facing material contains 20 weight % to 35 weight % of diatomaceous earth as said thermally insulating material, 1 weight % to 7 weight % of bentonite as said binder, 1 weight % to 5 weight % of said parting agent, 5 ppm to 50 ppm of said surface active agent, and the remainder of water.

5-6. (Canceled)

7. (Currently Amended) ~~A method~~ The method according to claim 4, wherein said mold is rotated at a mold G No. ranging from 25G to 35G when the inner surface of the mold is coated with the facing material.

8. (New) The cast-iron insert around which another metal is to be cast according to claim 1, wherein the protrusions have a height in a range of 0.5 mm to 2 mm above the surface for contact.

9. (New) The cast-iron insert around which another metal is to be cast according to claim 1, wherein the protrusions have a height in a range of 0.5 mm to 1.2 mm above the surface for contact.

10. (New) The cast-iron insert around which another metal is to be cast according to claim 1, wherein the surface of contact has a diameter ranging from 60 mm to 100 mm.

11. (New) The method according to claim 4, further comprising the step of machining an inner surface of the cast-iron insert after performing the step of positioning the clamping mechanism against the respective flat faces at distal ends of said protrusions in order to securely hold the cast-iron insert.

12. (New) The method according to claim 4, wherein the protrusions have a height in a range of 0.5 mm to 2 mm above the surface for contact.

13. (New) The method according to claim 4, wherein the protrusions have a height in a range of 0.5 mm to 1.2 mm above the surface for contact.

14. (New) The method according to claim 4, wherein the surface of contact has a diameter ranging from 60 mm to 100 mm.